

Duphaste

Work Order ID 84152

May-11-12 12:57:11 PM

84152

PRELIMINARY ISS

Item ID: D6021-125 Accept *N900040100* Setup Start *NS1*
Revision ID: Prelim Stop *NS2*
Item Name: Crosstube Material - 17-4PH SS
Start Date: 5/04/12 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 5/04/12 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 16389 Description: 17-4PH H1100 seamless Stainless
steel Tube, per ASTM A564 2.378"OD X2.00" ID X125" Long)
Min. Ultimate Tensile Strength=140ksi
Min. Yield Tensile Strength = 115ksi
Tolerance on all dimensions are as per Dwg D6021 Rev. PA1 and ASTM A519
Possible Supplier: Siderval
Material certification required

W 12-03-23

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

W 12-05-03

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
			P 12.05.11						
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
			N/A FOR TESTING ONLY P 12.05.11						
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL
 EFFECTIVE 5/20/11 AUTH h
 RELEASED _____ DATE _____

u 120523

Picklist Print

May-11-12 12:57:31 PM

Page 1

Work Order ID: 84152

Parent Item: D6021-125

Parent Item Name: Crosstube Material - 17-4PH SS

Start Date: 5/04/12

Required Date: 5/04/12

Start Qty: 4.00

Required Qty: 4.00

Comments: new issue - prelim LL 12.05.04

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6021-125P Crosstube Material - 17-4PH -H900		Purchased	No				Each	9.0000		4	✓ 84152		

Location

Loc Qty

Loc Code

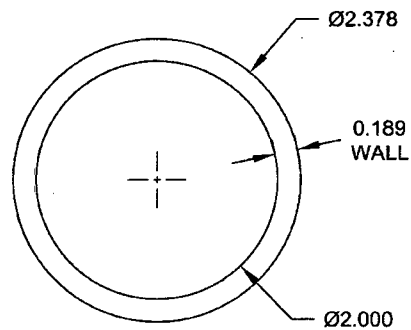
ST

120526

9

9

SPECIFICATION CONTROL DRAWING



W/O 8452

NOTES

- 1) D6021-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 125" LONG TUBE: D6021-125

- 2) MATERIAL: 17-4PH H1100 SEAMLESS STAINLESS STEEL TUBE PER ASTM A564
MIN. ULTIMATE TENSILE STRENGTH = 140 ksi
MIN. YIELD TENSILE STRENGTH = 115 ksi

- 3) TOLERANCES ARE PER ASTM A519 AS FOLLOWS:
O.D.: $+0.007/-0.000$
I.D.: $+0.000/-0.007$
LENGTH: $XXX +0.188/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

- 4) ALL DIMENSIONS ARE IN INCHES

- 5) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

PRELIMINARY ISSUE

Rev. PA1 12.05.04

REV.	NEW ISSUE	CP	12.05.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PA1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PA1		
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D6021	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE MATERIAL	NTS
DATE	12.05.04	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



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Tel. (0342) 67.41.11 (8 linee) - Fax (0342) 67.04.00
Indirizzo Internet: <http://www.siderval.it>
E-mail: siderval@siderval.it
Capitale Sociale € 2.860.000 int. versato
Società soggetta a direzione e coordinamento di
Calvi Holding Srl di Merate (LC)
R.I. Sondrio, C.F. e P.IVA 00072570146 - REA 25414

Amministrazione:
25047 BOARIO TERME (BS)
Viale A. Manzoni, 23
Tel. (0364) 53.42.47
Fax (0364) 53.45.25



SPECIAL STEEL PROFILES

EXPORT

23018 Talamona, 19/04/2012

RECEIVED APR 27 2012

ID NR. IT 00072570146

FATTURA N. / Invoice No. / Rechnung / Facture 893/2012		D.D.T. N. 810	
19/04/2012		19/04/2012	
N. CONFERMA / Sales conf. No / AB. Nr. / Conf. de vente 0338.2 DEL 09/03/2012		CODICE FISCALE / PARTITA IVA *non comun.*	
ORDINE / Order / Bestellung / Commande PO16389		PAGINA / Page / Seite / Page 1	RAPP. 20
DATA ORDINE 09/03/2012	SPEDIZIONE / Transport / Versand / Expedition BY AIR		
RESA / Delivery / Lieferung / Rendue DAP HAWKESBURY, ON K6A 1K7		CODICE CLIENTE 70.0013	
PAGAMENTO / Payment terms / Zahlung / Paiement 30 days from mat.recept.			
BANCA D'APPOGGIO / Bank / Bank / Banque			

SPETTABILE

DART AEROSPACE LTD.

**1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA**

DESTINAZIONE / Delivery address / Versandanschrift / Destination

**DART AEROSPACE Ltd.
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA**

CONTATTO

**MRS.LINDA LACELLE
+1 613 632 9577
+1 613 632 1053**

POS.	DESCRIZIONE / DESCRIPTION / BESCHREIBUNG / DESCRIPTION	PROF. NR.	N. pezzi No. pieces Stückzahl Nr. pieces	Quantità Quantity Menge Quantité Kg.	Prezzo / Price Preis / Prix	U.M.	Importo / Amount Betrag / Montant USD
1	SPECIAL HOT EXTRUDED TUBE IN SS.17-4-PH as ASTM A564 acc.to our Dwg.PRE/12058-B of 02/09/11, Nr.04 straight bars in Cutting length of 125"+4"/-0" Ø 2.378" x 2.00" Ref.D6021-125P Ln.1 TARIFFA DOG.: 72.22.40.10 ===== MATERIAL MADE IN ITALY ===== GROSS WEIGHT KG.142 NET WEIGHT KG.82 NR.1 WOODEN BOX DIM.250X250X3400 MM. =====	5112	4	82	663,02	PZ	2.652,08
2	AIR FREIGHT COSTS (to be determined at the time of release)	9909	1		2.200,00 <i>-11</i>	PZ	2.200,00

IMP. NON SOGG. USD	IMP. ESENTE USD	IMPONIBILE USD	I.V.A. USD	IMPONIBILE 21% USD	I.V.A. 21% USD	TOTALE FATTURA / TOTAL AMOUNT ENDBETRAG / MONTANT TOTAL
						USD €



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	COMPLETE Shipment P.O. n. PO16389 WODDEN BOX NON IMP.ART.8,P.A-NON RES QUALIFICAZIONE AC1 PRODOTTI 1° SCELTA COME DA DEF.CIRC. 20/87 DEL 14/05/87 MERCE DESTINATA ALL'ESPORTAZIONE =====		NR.	1			Tot.peso: 82
	PAYMENT WIRE TRANSFER =====						

Personal data Protection - Law n. 196/03

Pursuant to art. 13 of Italian Legislative Decree no. 196 of 30th June 2003, entitled "Personal Data Protection Law", we inform you that we shall process your general and tax data, as well as data of an economic nature that is necessary to perform the current or future contractual relations with your company. Your data shall be treated in relation to the contractual requirements, and the fulfilment of the legal and fiscal obligations. The data shall be processed by the use of instruments and procedures that are suitable to guarantee security and confidentiality and shall be performed on both paper and computer support. We would like to remind you that you can exercise the rights outlined in art. 7 of the Consolidated Act contacting us.
The Data Controller is Siderval S.p.A., Roma street, 39/C - 23018 Talamona (So).

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4.852,08						USD 4.852,08
						€ 3.705,86

BANK BCA POP.SONDRIO-BOARIO T.(BS) NR.CONTO VARUS0002558

SWIFT: POSOIT22

IRAN IT 33Y0569654440VARUS0002558



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SWIFT : POSOIT22
IBAN IT33Y0569654440VARUS0002558

LABORATORIO CONTROLLO QUALITA'

ISPESL Istituto Superiore Prevenzione e Sicurezza del Lavoro
 FS Ferrovie dello Stato BV Bureau Veritas
 LR Registro Italiano Navale DNV Det Norske Veritas
 RINA Lloyd's Register of Shipping MM Marina Militare Italiana
 IIS Istituto Italiano della Saldatura TUV Technischen Überwachungs Vereine

Sigma Tre

TEST - RESEARCH - EXPEDITING

Rapporto di prova
 Test Report **2012/0245/A/ND**

Garbagnate M.ero 2012 April 18

Ordine Interno
 Internal Order 2012/0845

Materiale Ricevuto il
 Material Received on —

Prove Eseguite il
 Test Performed on 2012 April 17

Ditta/Messrs

Request by

SIDERVAL S.P.A

Via Chini Battista 60

23018 TALAMONA

SO

Campione sottoposto a prova
 Tested Specimen

Materiale dichiarato
 Material declared

Specifiche di Prova
 Test Specifications

Ultrasonic Examination
 of nr. 4 bars

17-4-PH

EN 10246-7 Level U2
 Sub Category C

Colata / Heat

Extension: 100% accessible zones

See description below

05615

CONTROLLI NON DISTRUTTIVI - NOT DESTRUCTIVE TESTS

Esame Ultrasuoni - Ultrasonic Examination

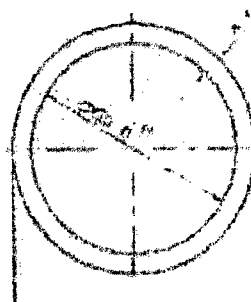
Apparecchiatura utilizzata - Used equipment

Apparecchio Equipment	Modello Type	Sonda Probe	Sonda Probe	Blocco Calibrazione Calibration block	Calibrazione Calibration	Controllo Control	Accoppiamento Coupling	Superficie Surface
Gilardoni	RG20	DP 10/4	DP 25/4	V1-V2 I.I.W.	ASTM A 388	+6 dB	Oil SAE H 30	Estruso Extruded

Siderval profile 05112

Order PO16389 C.V.338.2

Nr. 4 bars - L = 3175 mm - Lot 12/806



Note : Absence of indications

CONFORM



Tecnico-Engineer
 G. Vigorelli

cm

SIGMATRE srl



Tecnico - Operator
 X Italo Carozzi

SIGMATRE srl

ND03-2012-00

Il presente rapporto riguarda esclusivamente i campioni testati e non può essere riprodotto parzialmente senza l'approvazione scritta del laboratorio di prova.
 The present report covers exclusively the samples tested and it cannot be reproduced partially without written approval by the test laboratory

page 1 of 1

SigmaTre srl - Capitale Sociale Euro 89.500 i.v.
 Via Fornace 31 - 23846 Garbagnate Monastero (Lecco)
 Tel. +39 031 87 94 25 - Fax +39 031 87 94 22

• Prove Meccaniche e Tecnologiche
 • Analisi Chimiche e Prove Corrosione
 • Esami Metallografici

• Mechanical and Technological Tests
 • Chemical Analysis and Corrosion tests
 • Metallographic Examination



DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Talamona, 19 April 2012

PACKING LIST

ORDER 80786 - Invoice 1996/2008

Profil	C.V.	Heat Nr.	Nr.bundles	Quantity (Kg)	Nr.bars
5112	338.2	05615	01/01	82	4

82

Gross weight kg.142

Net weight kg.82

Nr.1 wooden box Dim.250x250x3400 mm.

Material Made in Italy

SIDERVAL SPA